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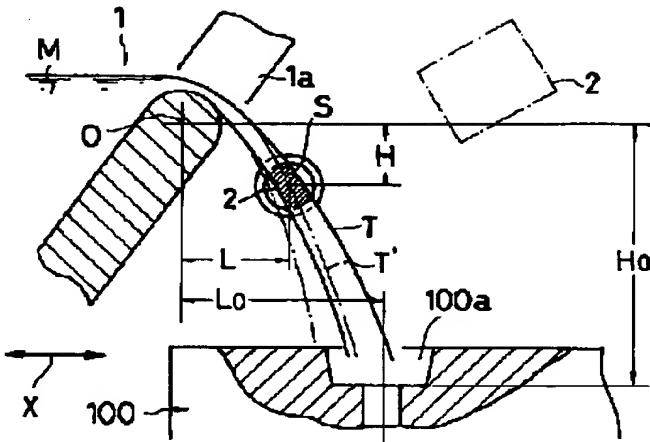
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TITLE : AUTOMATIC METHOD FOR POURING MOLTEN METAL



ABSTRACT : PURPOSE: To provide an automatic molten metal pouring method, which can stabilize the quality of a product and particularly, can suitably execute by using a ladle tilting type molten metal pouring device and a stopper-nozzle type molten metal pouring device, by achieving the automation of the molten metal pouring work in safety and good working efficiency without precisely manufacturing the ladle and the other equipment.

CONSTITUTION: At the prescribed position (L, H) in the vicinity of a molten metal pouring hole 1a in the ladle 1, an image pick element image sensor 2 is arranged and positional variation of pouring flow line T of the molten metal dropped from the pouring hole 1a is picked up as a video, and by measuring the position of the projecting image S, the positional variation of the molten metal pouring flow line at this time is calculated. When the detected positional signal is smaller than the reference signal, i.e., when the molten metal pouring flow line T shifts to the left side in the figure and becomes to the molten metal pouring flow line T', the ladle 1 is shifted to the right side direction in the arrow X direction in the figure by a driving means. On the other hand, when the detected positional signal is larger than the reference signal, i.e., when the molten metal pouring flow line T shifts to the right side in the figure, the ladle 1 is shifted to the left side direction in the arrow X direction in the figure by the driving means.

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